

Work Order ID 71735

Monday, July 11, 2011 11:10:21 AM



Page 1

Item ID: D4306-044	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib Assembly, RH					
Start Date: 7/11/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 7/21/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: <u> H </u>	Date: <u>11/07/11</u>	Tooling:	Date: <u> </u>	Run	Start	
	QC: <u> </u>	Date: <u> </u>	SPC (Y/N): <u> </u>	Date: <u> </u>		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4306	C								

100 Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Large Fab

Memo 0.00

- 1- Cut tube 52"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size and cut notch as per dwg D4306-4
- 4- Drill and chamfer holes as per dwg D4306-4 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

SAD 4-67-20

① PC 11.07.20

110 QC6- Inspect dimensions to drawing 0.00



QC

Quality Control

Memo 0.00

11 07 20 ①

W/O:		WORK ORDER CHANGES					
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Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

[Signature] 11-07-20 ①

130

Identify as per dwg & Stock Location: *B/C*

0.00



Packaging

Memo

0.00

Packaging

[Signature] 11-07-20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

[Signature] 11/7/25

mk
11-07-20

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Picklist Print

Monday, July 11, 2011 11:10:27 AM

Page 1
1

Work Order ID: 71735



Parent Item: D4306-044



Parent Item Name: Rib Assembly, RH

Start Date: 7/11/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Manufactured No

100

Each

215.0000

4

4



Bushing



SAD 11-07-21

Location

Loc Qty

Loc Code

WA

200

69202

200

WA005

15

66489

2

66870

13

(4)

M304TS0.750W.049

Purchased

No

100

f

482.2674

4.166

4.385263



SAD 11-07-21

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

167.087

117690

38.2654

117775

128.8216

MAT034

15.1804

117337

15.1804

WA

300

118184

300

4.3853

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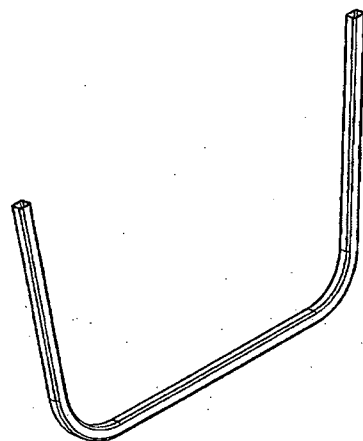
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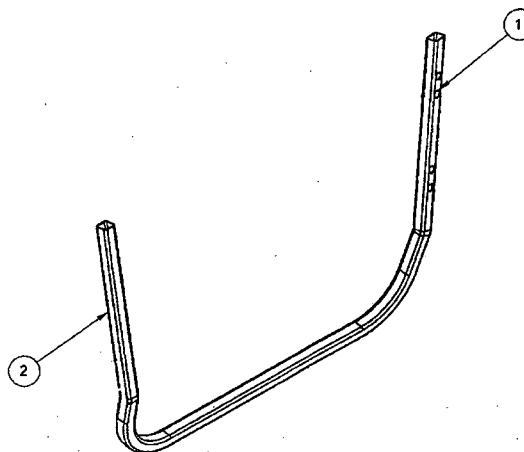
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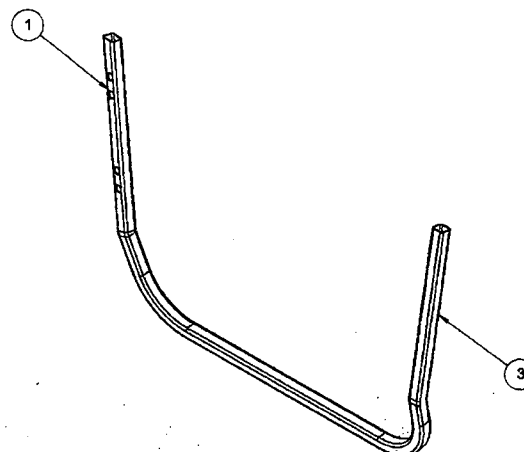
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



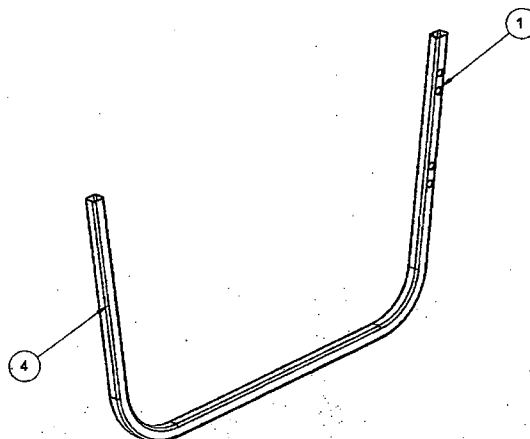
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71735

2011-07-11

RELEASED
2011-03-18

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
DATE	11.02.09		

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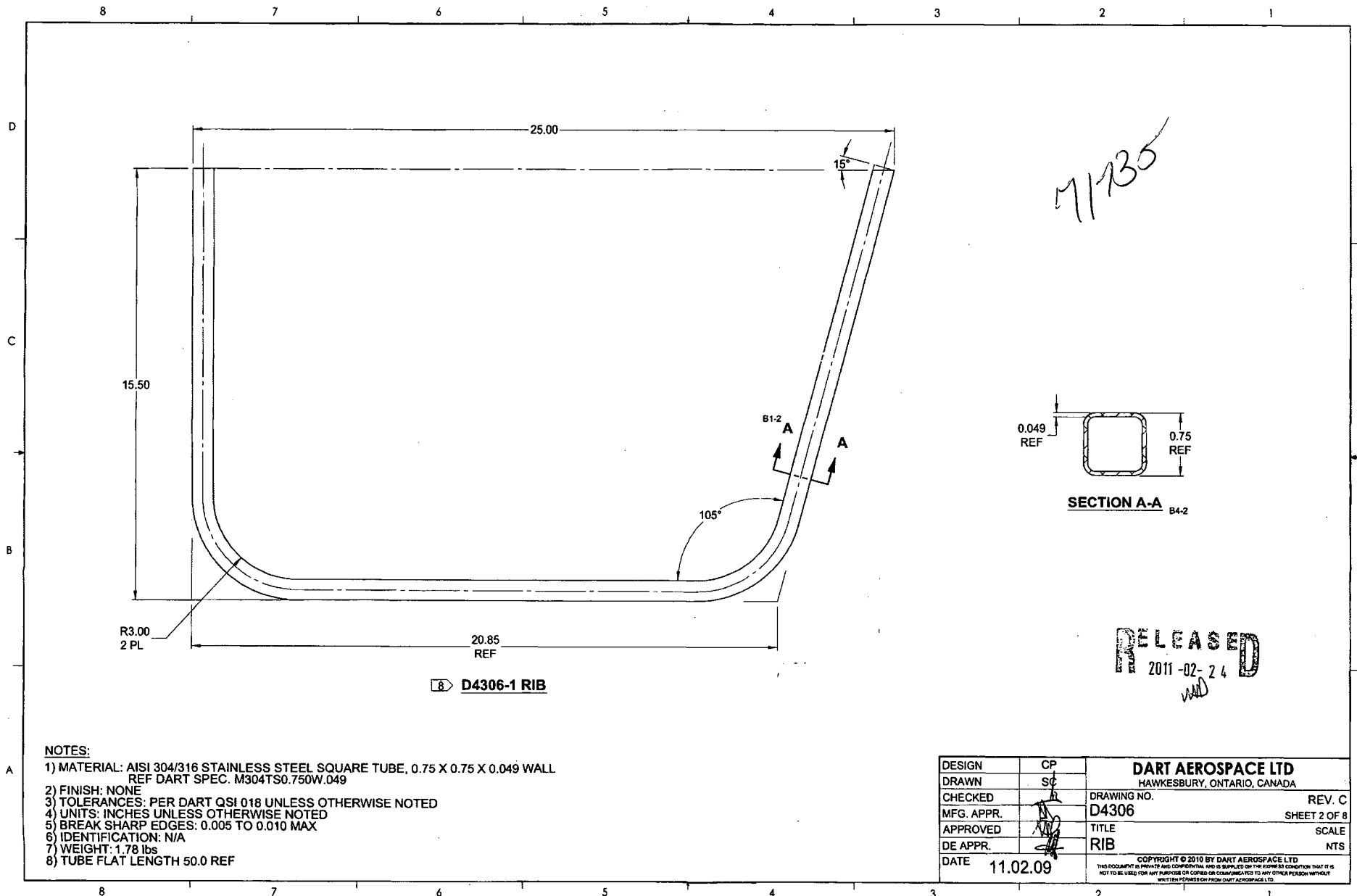
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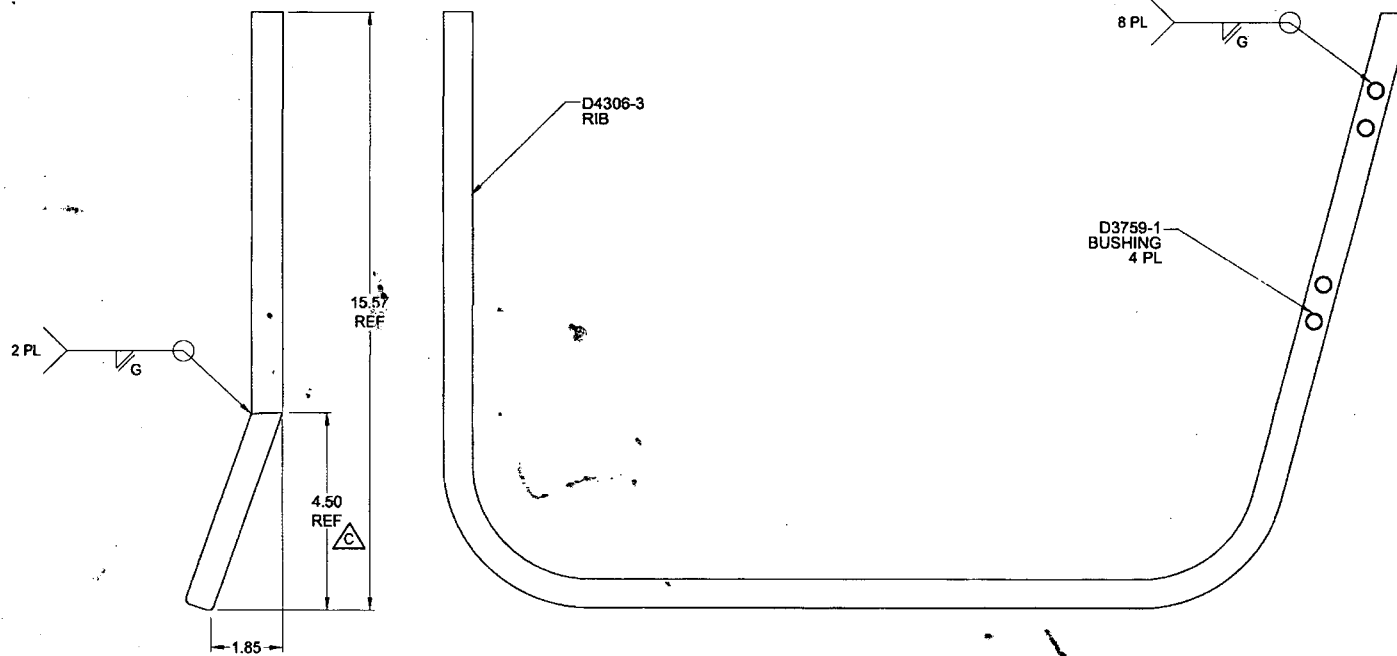
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D4306-043 RIB ASSY, LH

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
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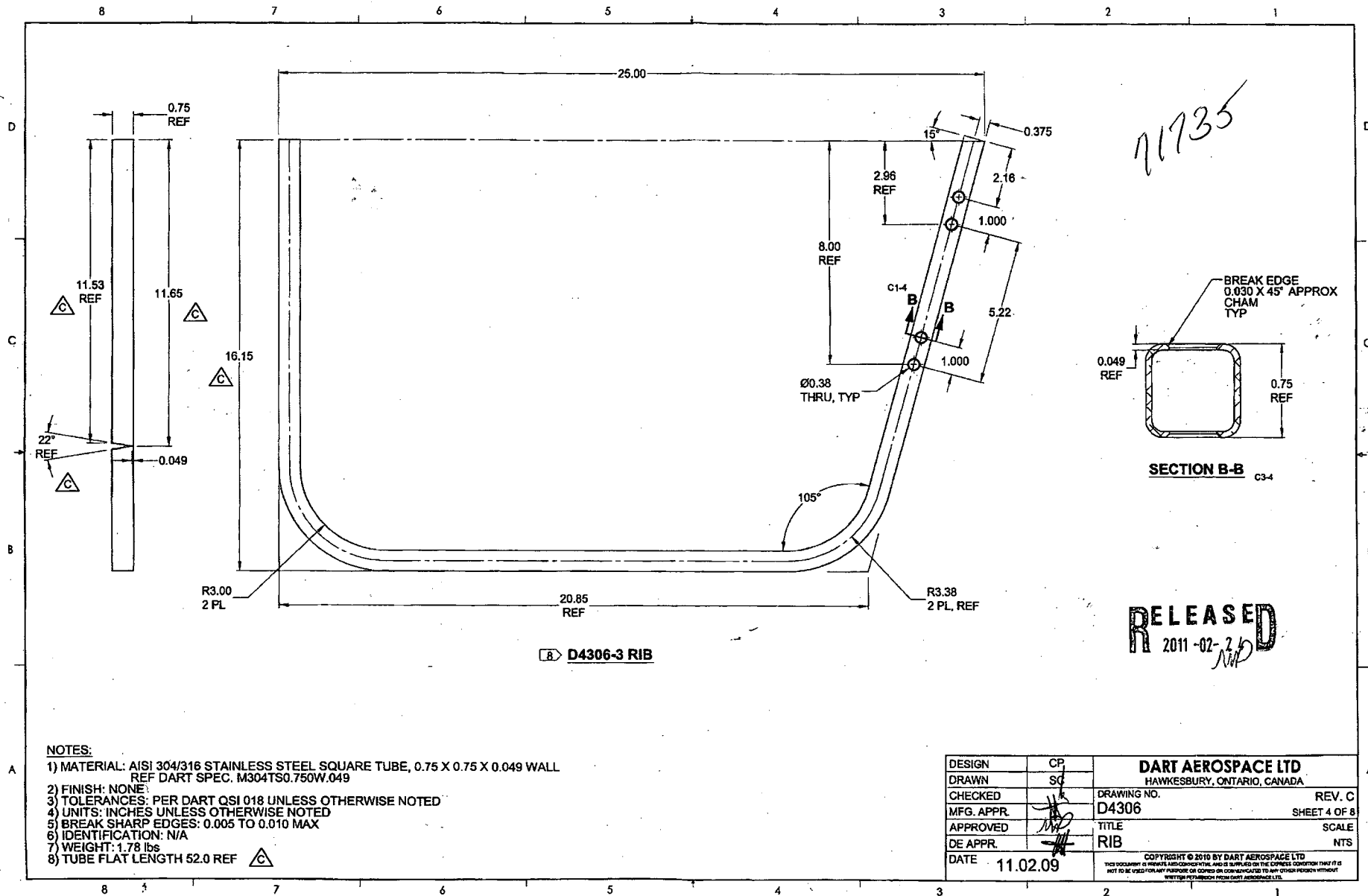
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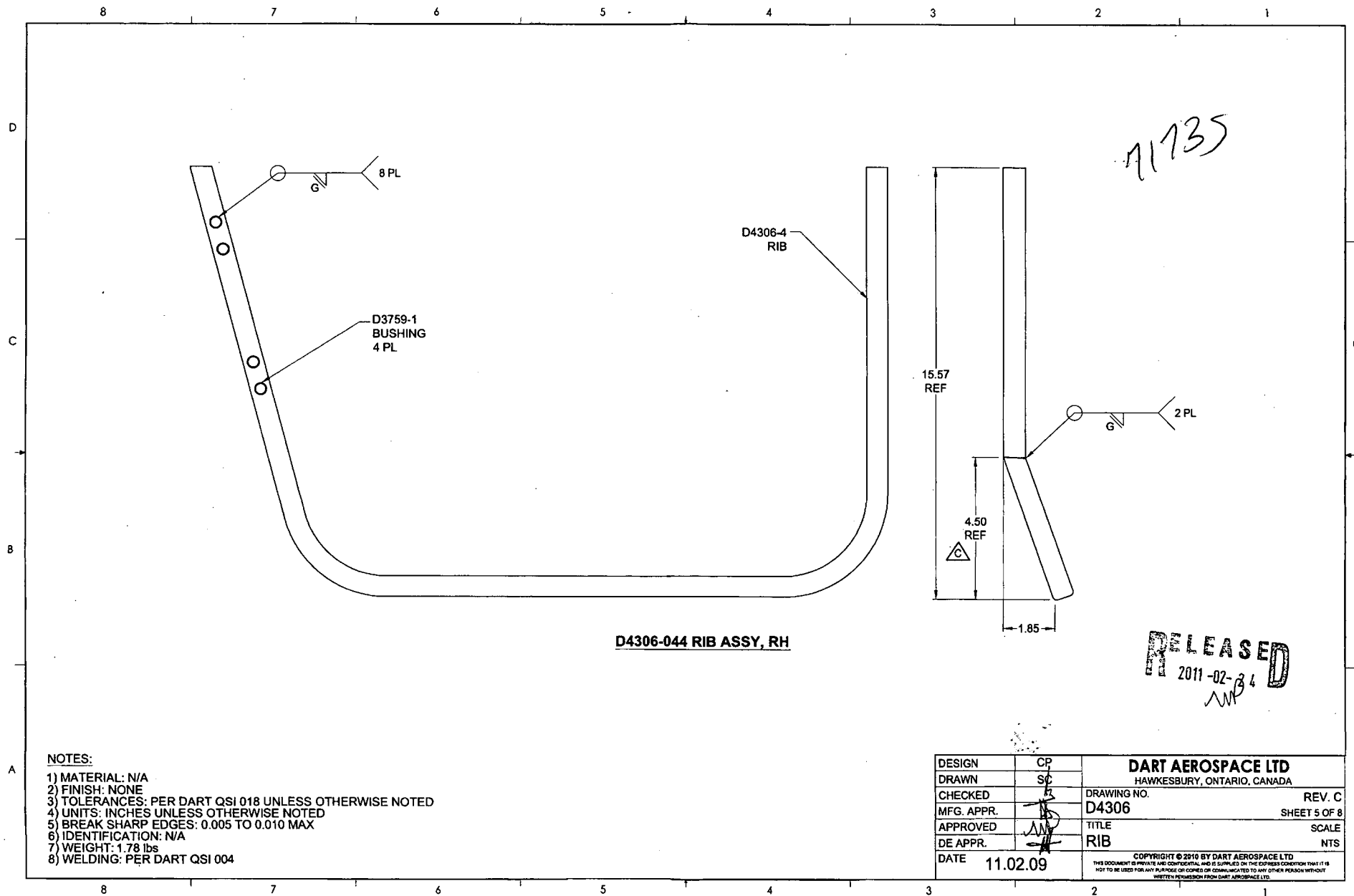
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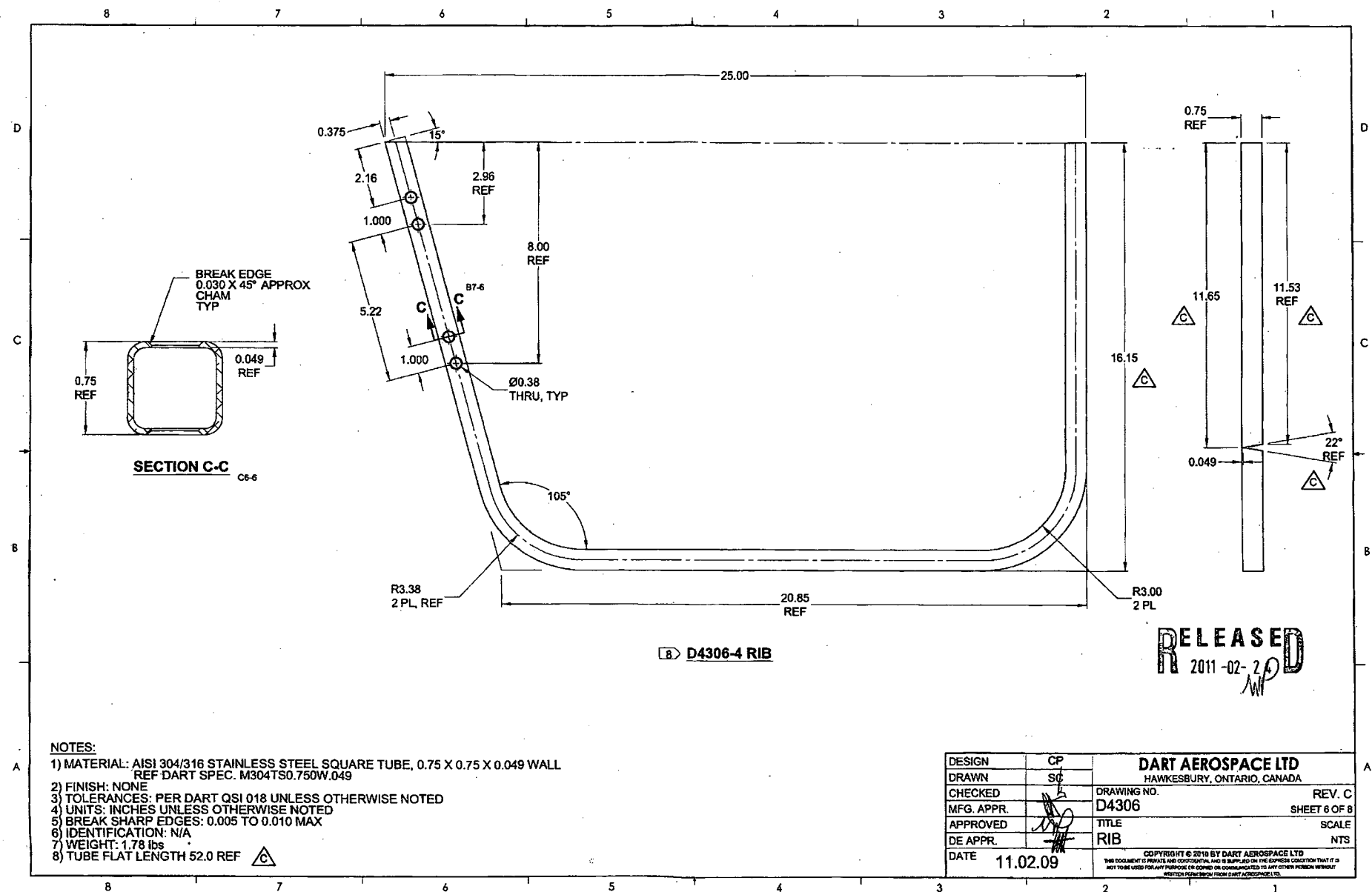
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71735



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

DESIGN	CP	DART AEROSPACE LTD	
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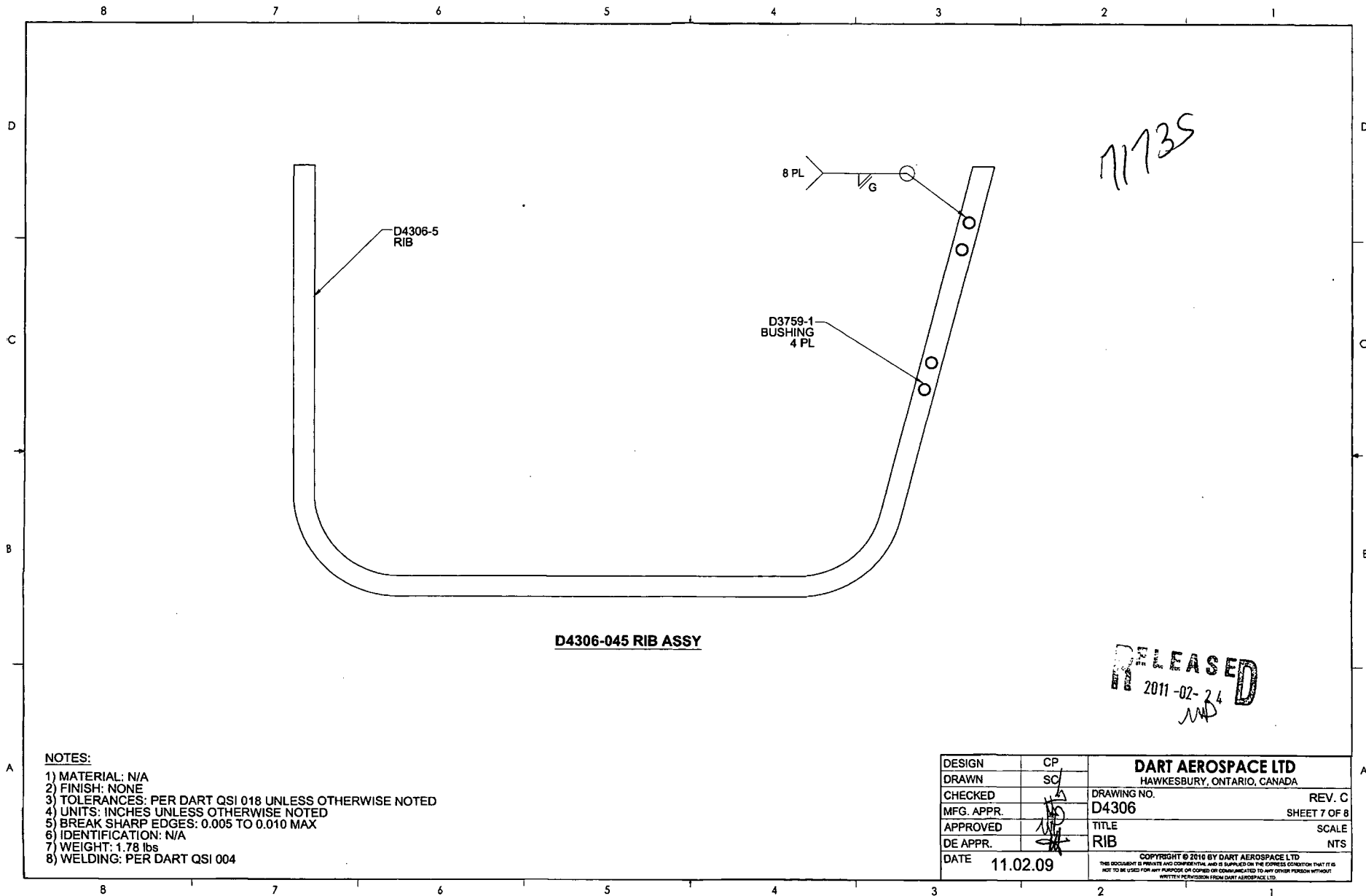
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